

Date: Tuesday, 7/18/2006 3:00:41 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE, INBOARD, LS, 206
Job Number : 27966	
Estimate Number : 10820	
P.O. Number : <u>NIA</u>	Part Number : D26661
This Issue : 7/18/2006 S.O. No. : <u>NIA</u>	Drawing Number : D2666 REV. C
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>NIA</u> Type : MACHINED PARTS	Drawing Revision : C
Previous Run : 27770	Material : <u>NIA</u>
Written By : <u>[Signature]</u>	Due Date : 8/10/2006 Qty: 12 Um: Each
Checked & Approved By : <u>[Signature] 06.07.19</u>	
Comment : Est: C 06.11.01 Removed P/O for Powder Coat - in house processEC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101001	7075-T7351 2X6X6.25
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

7075-T7351 2X6X6.25

Issue material from stock:

Cut Size 2.0 x 6.25 X 6.0

Grain Along Long 6.0 Length

Batch No: B25342

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Program batch number.

1-Inspect part number and batch number are programmed correctly.

2-Fixturing Inspection last completed on 06.07.15 by SA

3-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet

6-Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet

8-Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet

9- Deburr

IL/SA 06.07.30

(P)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

IL 06/08/15


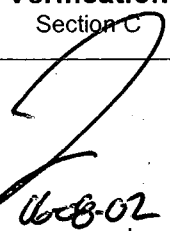
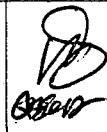
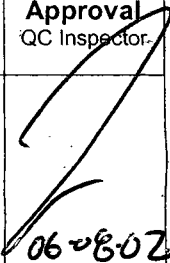
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

IL/SA 06.07.30

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06.07.31	2.0	25° - 40° .045 X 0.15 X .15 chamfer was done at the inside bottom of the saddles, by the machine operator, on 3 saddles. Chamfer machined during squaring on the 1st operation, on the billet.		Deviation Acceptable.	J.L. 06/08/02	 06-08-02	 06-08-02	 06-08-02

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: JA Date: 06.08.24

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 7/18/2006 3:00:41 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, INBOARD, LS, 206

Job Number: 27966

Part Number: D26661

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

ml 06/08/15

12

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FC 06 08 16 (12)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m 06-08-22

(12)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

sl 06/05/23 (12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *52471*

sl 06/05/23 (12)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

1106.08.24

Job Completion



W 06/08/23

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date				

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order: 27966
Description: 206 Saddle, Inboard, Left side	Part Number: D2666-1
Inspection Dwg: D2666 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.120	.120	.120	.121		
B	0.100	0.140		.112	.121	.122	.124		
C	2.470	2.510		2.495	2.495	2.495	2.495		
D	0.100	0.180		.130	.130	.130	.130		
E	0.210	0.230		.220	.221	.223	.224		
F	1.313	1.343		1.326	1.329	1.326	1.322		
G	0.240	0.260		.249	.249	.249	.246		
H	0.615	0.685		.655	.655	.655	.655		
I	1.125	1.145		1.136	1.136	1.138	1.137		
J	0.990	1.010		1.001	1.000	1.001	1.001		
K	0.235	0.240		.238	.238	.234	.238		
L	0.510	0.515		.514	.514	.514	.514		
M	0.100	0.120		.112	.114	.111	.111		
N	1.565	1.585	DT8688	5.998	5.998	5.997	5.998		
O	5.990	6.010		5.998	5.998	5.997	5.998		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	1.500	2.500	2.500		
R	0.490	0.510		.499	.501	.498	.498		
S	0.313	0.318	DT8686	2.500	2.499	2.499	2.500		
T	2.495	2.505		1.362	1.362	1.362	1.362		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.313	0.318	DT8686	.550	.550	.550	.551		
W	0.540	0.560		1.679	1.679	1.679	1.679		
X	1.674	1.684							
Y	0.257	0.262	DT8683						
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: J.L.	J.L.
Date: 06/07/28	06/08/15

Audited by: J.L.	
Date: 06/08/15	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD	Work Order: 27966
Description: 206 Saddle, Inboard, Left side	Part Number: D2666-1
Inspection Dwg: D2666 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.123	.121	.121	.122		
B	0.100	0.140		.124	.124	.125	.130		
C	2.470	2.510		2.494	2.498	2.488	2.495		
D	0.100	0.180		.130	.130	.130	.130		
E	0.210	0.230		.225	.225	.226	.230		
F	1.313	1.343		1.322	1.324	1.323	1.331		
G	0.240	0.260		.250	.250	.251	.251		
H	0.615	0.685		.655	.655	.655	.655		
I	1.125	1.145		1.137	1.138	1.143	1.137		
J	0.990	1.010		1.002	1.001	1.007	1.001		
K	0.235	0.240		.238	.238	.238	.238		
L	0.510	0.515		.514	.514	.514	.514		
M	0.100	0.120		.113	.112	.112	.114		
N	1.565	1.585	DT8686						
O	5.990	6.010		5.998	5.998	5.998	5.998		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.490	0.510		.496	.498	.496	.494		
S	0.313	0.318	DT8686						
T	2.495	2.505		2.500	2.500	2.499	2.501		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.313	0.318	DT8686						
W	0.540	0.560		.549	.549	.550	.550		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262	DT8683						
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	SD
Date:	06.07.30/06/08/15

Audited by:	9.2
Date:	06/08/15

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD	Work Order:	27966
Description: 206 Saddle, Inboard, Left side	Part Number:	D2666-1
Inspection Dwg: D2666 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.124	.125	.125	.126		
B	0.100	0.140		.129	.129	.129	.129		
C	2.470	2.510		2.493	2.493	2.493	2.493		
D	0.100	0.180		.130	.130	.130	.130		
E	0.210	0.230		.229	.230	.228	.230		
F	1.313	1.343		1.328	1.329	1.329	1.327		
G	0.240	0.260		.255	.255	.256	.256		
H	0.615	0.685		.655	.655	.655	.655		
I	1.125	1.145		1.137	1.135	1.137	1.137		
J	0.990	1.010		1.001	1.001	1.001	1.001		
K	0.235	0.240		.238	.238	.238	.237		
L	0.510	0.515		.514	.514	.514	.514		
M	0.100	0.120		.112	.113	.112	.112		
N	1.565	1.585	DT8686	1.565	1.565	1.565	1.565		
O	5.990	6.010		5.998	5.998	5.998	5.998		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.490	0.510		.498	.499	.500	.497		
S	0.313	0.318	DT8686	0.313	0.313	0.313	0.313		
T	2.495	2.505		2.501	2.500	2.500	2.501		
U	1.357	1.367		1.363	1.363	1.363	1.363		
V	0.313	0.318	DT8686	0.313	0.313	0.313	0.313		
W	0.540	0.560		.551	.550	.548	.550		
X	1.674	1.684		1.679	1.679	1.679	1.675		
Y	0.257	0.262	DT8683	0.257	0.257	0.257	0.257		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

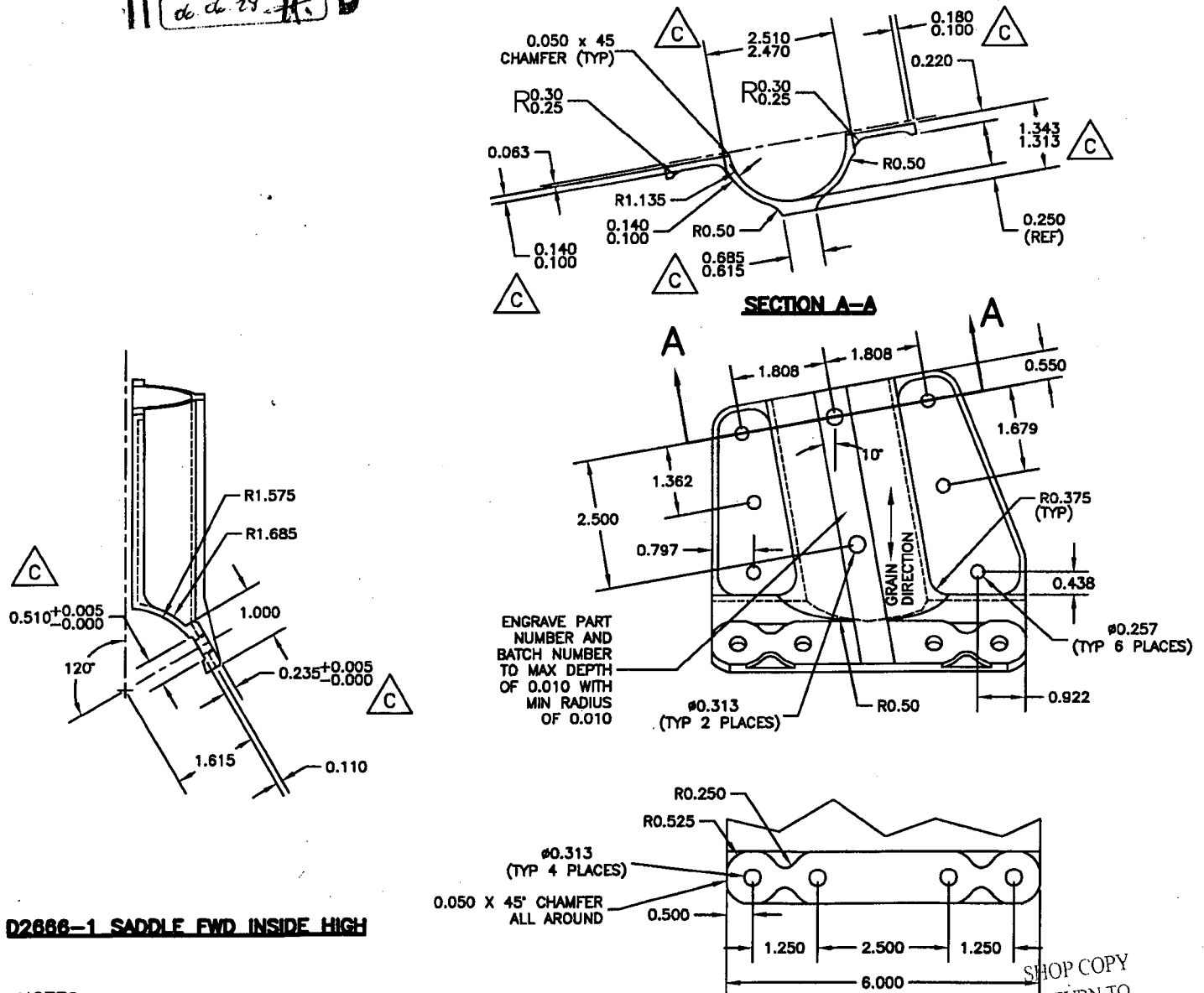
Measured by:	SD
Date:	06.07.30/06/08/15

Audited by:	ML
Date:	06/08/15

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	

DART**RELEASED**
de de 29 Hs

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
	C.B.	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. C
		D2666	SHEET 1 OF 1
DATE		TITLE	SCALE
06.05.26		SADDLE FWD INSIDE HIGH	1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.26	INCORPORATE DEO 9122, 9102, 9095	

**D2666-1 SADDLE FWD INSIDE HIGH****NOTES:**

- 1) MATERIAL: 7075-T7351 (QQ-A-250/12) (REF DART SPEC M7075T73B)
- 2) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE PER DART QSI 005 4.3.5.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2666-1 SHOWN (D2666-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27966

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